

Work Order ID 164029

Tuesday, July 11, 2017 12:50:12 PM

164029

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Item ID: D5090-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 7/13/2017 Start Qty: 14.00

14

Cust Item ID:

Required Date: 7/21/2017 Req'd Qty: 14.00

14

Customer:

Reference:

Approvals:

Process Plan: ✓

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D5090	CUR D <u>per</u>	<u>real</u>

100

0.05

100

FLOW WATER JET

Waterjet

Memo

0.49

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: DProg Rev: b

2-Deburr as required

(28)

2/17/07/12

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.14

Quality Control

(28)

2/17/07/12

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N900040100

Setup Start *NS1*

Stop *NS2*

14

14

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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0.00

150

HandFinish

Memo

1.28

Hand Finishing

0.00

160

OC

Memo

0.00

Quality Control

0.00

170

QC

Memo

AS
38 0.28
-89

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Item ID: D5090-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket
 Start Date: 7/13/2017 Start Qty: 14.00 *14* Cust Item ID:
 Required Date: 7/21/2017 Req'd Qty: 14.00 *14* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <i>GA</i> Memo	0.00 0.14				<i>28</i>	<i>Ø</i>	JUL 18 2017	<i>19</i> 9-00
200 *200* QC Quality Control	QC21 - Final Inspection - Work Order Release Memo	0.00 1.40						<i>17/7/2017</i>	

P
JUL 18 2017

Picklist Print

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Work Order ID: 164029

164029

Parent Item: D5090-3

D5090-3

Parent Item Name: Bracket

Start Date: 7/13/2017

Required Date: 7/21/2017

Start Qty: 14.00

Required Qty: 14.00

Comments: IPP REV:A 14.06.18 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	150.5700	0.7	10.31579			

M6061T6S 040

**

07/17/12

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT

34.2

m137165

34.2

25

MAT021

116.37

m137518

52.37

m137980

64

3.6

DART AEROSPACE LTD		Work Order: 164029	
Description: Bracket		Part Number: D5090-3	
Inspection Dwg: D5090		Page 1 of 1	

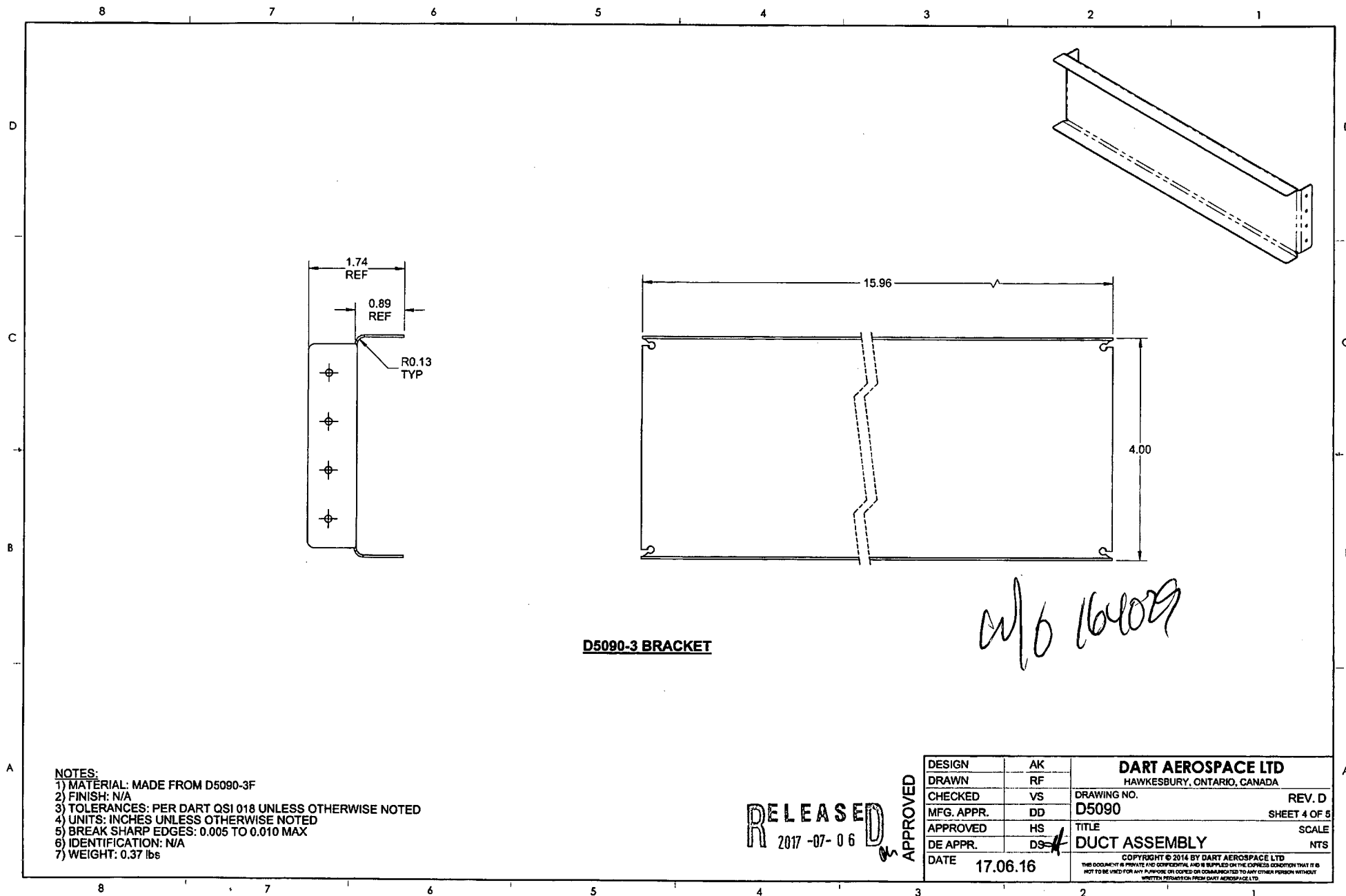
INSPECTION SHEET

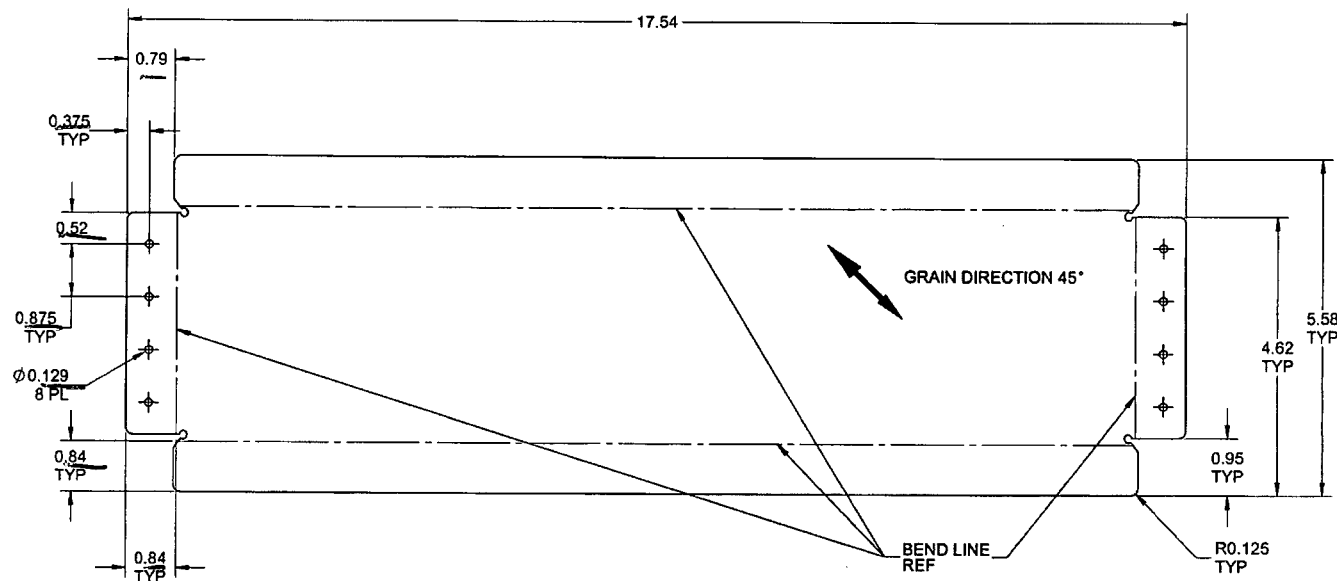
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.58	+/-0.030					
4.54	+/-0.030					
1.04	+/-0.030					
0.88	+/-0.030					
17.54	+/-0.030					
2.75	+/-0.030					
0.86	+/-0.030					
1.04	+/-0.030					
0.20T	+0.005/-0.001					
φ.129	-.001 +-.005	φ.130	1			
.84	+/- .030	.84	1			
.52	+/- .030	.52	1			
.375	+/- .010	.379	1			
.875	+/- .010	.876	1			
.79	+/- .030	.79	1			
.95	+/- .030	.95	1			
4.62	+/- .030	4.62	1			
5.58	+/- .030	5.58	1			
17.54	+/- .030	17.54	1			
1.040	+/- .010	1.040	1			

Measured by: [Signature]	Checked by: 38	QC Inspector:
Date: 17/07/12	Date: JUL 12 2017	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.06.27	New Issue	KJ	
B	15.07.28	Dwg Rev updated	KJ	
C	15.11.03	Dwg Rev updated	KJ	[Signature]





D5090-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M8081T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.37 lbs
- 8) UNDEFINED FEATURES ARE CONTROLLED BY D5090-3F.DXF

RELEASED
2017-07-06

APPROVED
DATE

DESIGN	AK	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. D
MFG. APPR.	DD	D5090	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	DUCT ASSEMBLY	NTS
DATE	17.06.16	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	